

Date: Monday, 27/04/2009 1:05:26 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARING ASSEMBLY
Job Number :	47551		
Estimate Number :	11136		
P.O. Number :		Part Number :	D3183045
This Issue :	27/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3183 REV C1
First Issue :	11	Project Number :	N/A
Previous Run :	46393	Drawing Revision :	C1
	Type :	Material :	
	MACHINED PARTS	Due Date :	27/04/2009
Written By :		Qty:	40 Um: Each
Checked & Approved By :	C209/04/27		
Comment :	Est A04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0350 f(s)/Unit Total: 1.7483 f(s)
 Delrin Round Bar 1"
 Material: Ø1.00 Delrin Rod
 (M-DELIN-R1.000)
 Identify as D3183-9
 Batch: _____

C209/04/27

N/A

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Turn D3183-9 Cap as per Folio FA388
 Deburr

pull from stock.

N/A C209/04/27

B47280 x40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N/A C209/04/27

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N/A C209/04/27

5.0	D31835	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
 Pick:

Qty Part Number	Description	Batch
1 D3183-5	Bearing	

2 x B46392		
2 x B46392		

2 x B46392	22
2 x B46392	22

C209/04/27

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Part Number: D3183045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/27 (40)
counts
5 09/04/27 (x40)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *236A*

9/4/27

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/27
[Signature]

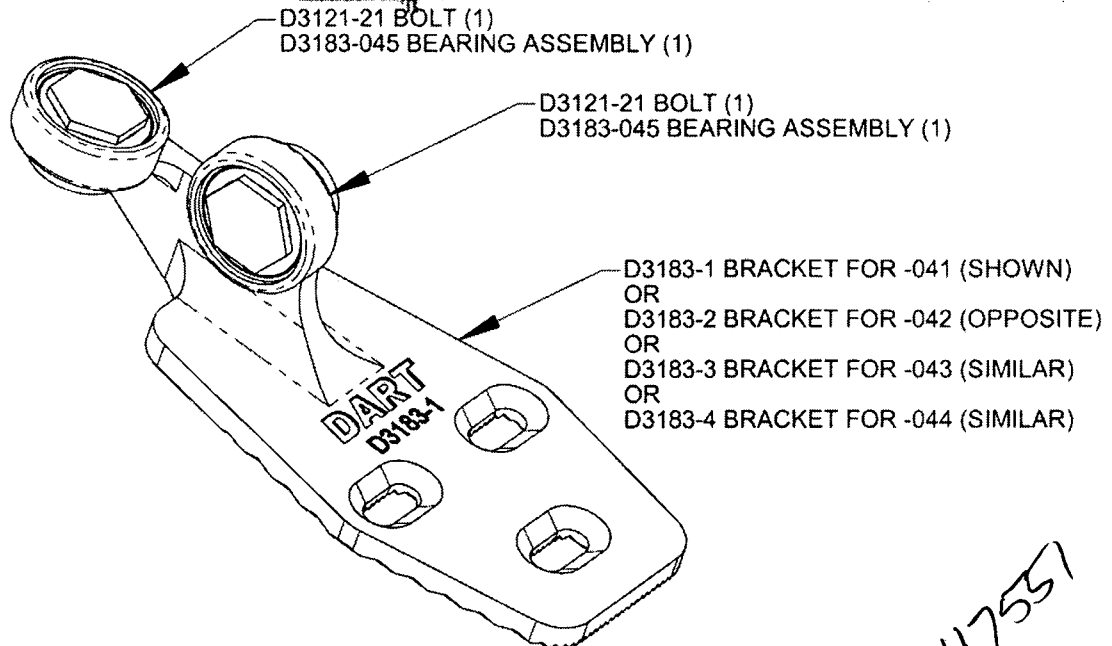
Job Completion



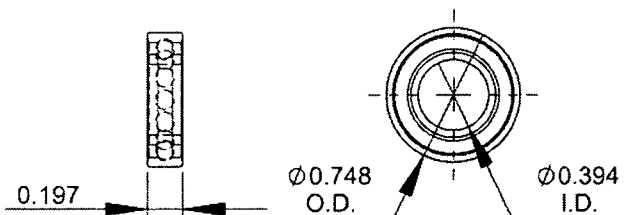
C 209/04/27

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.07	0.830 WAS 0.850	

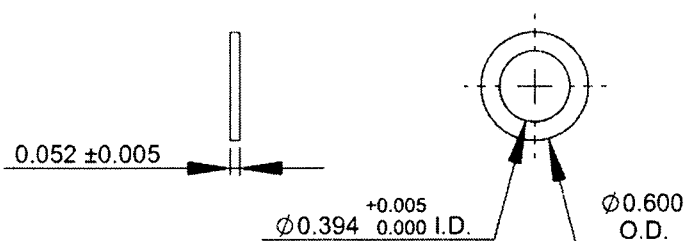
RELEASED
04 03 01

D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

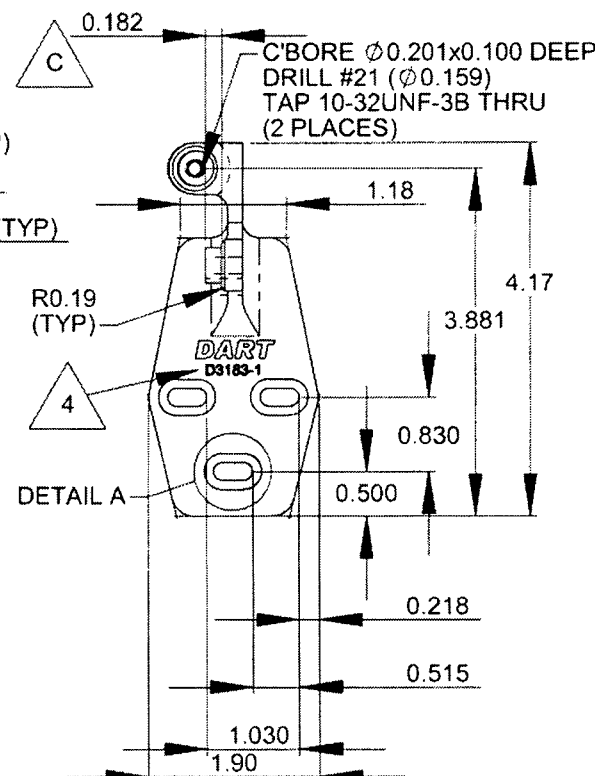
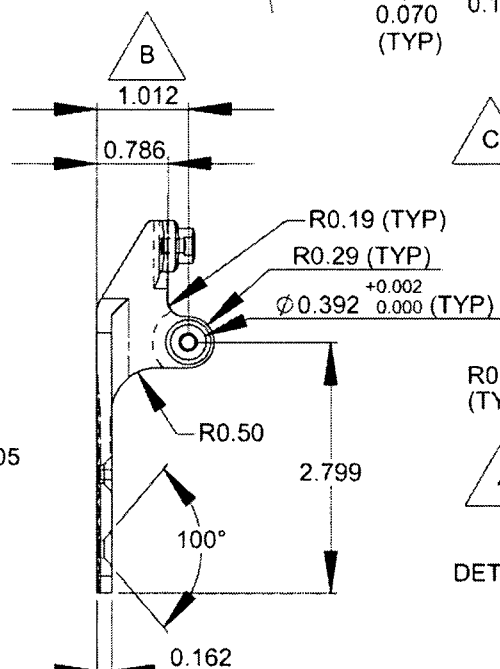
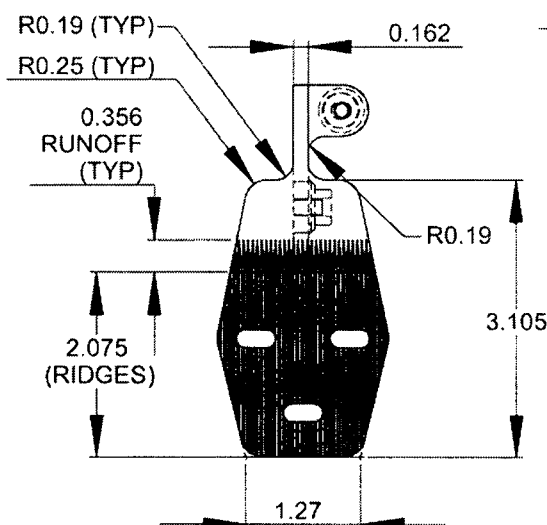
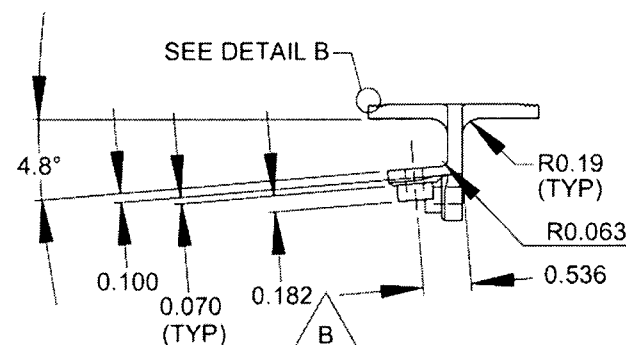
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
04.02.17	D3183	SHEET 2 OF 4
	BRACKET ASSEMBLY	SCALE 1:2



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

47551

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<i>[Signature]</i>	<i>[Signature]</i>	D3183	SHEET 3 OF 4
DATE		TITLE	SCALE
04.02.17---		BRACKET ASSEMBLY	1:2



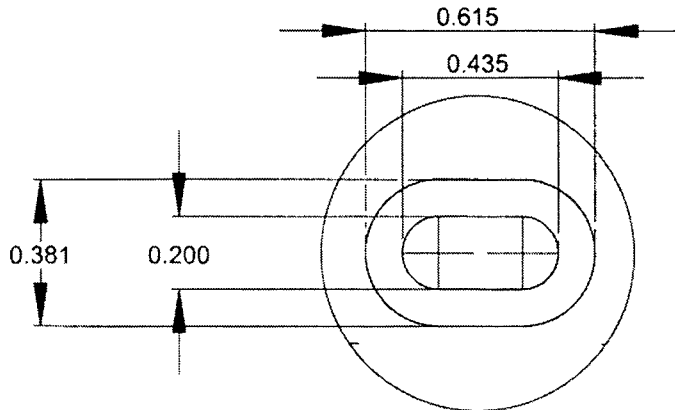
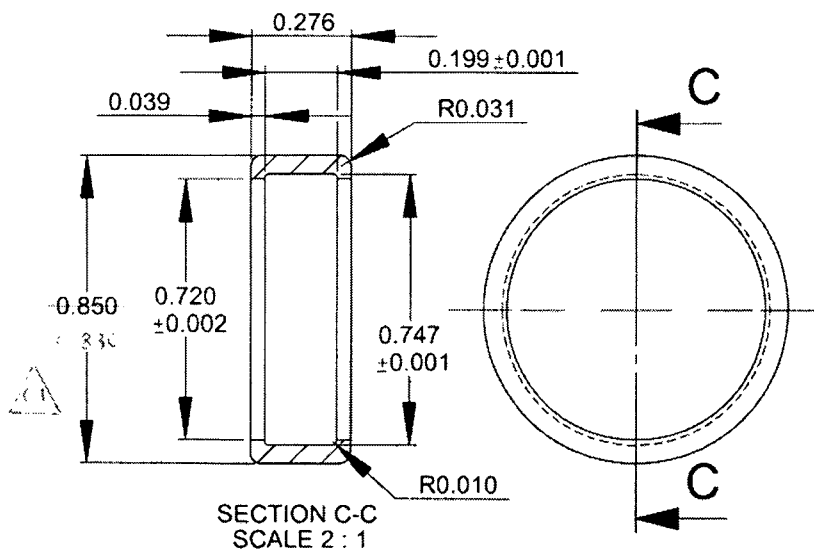
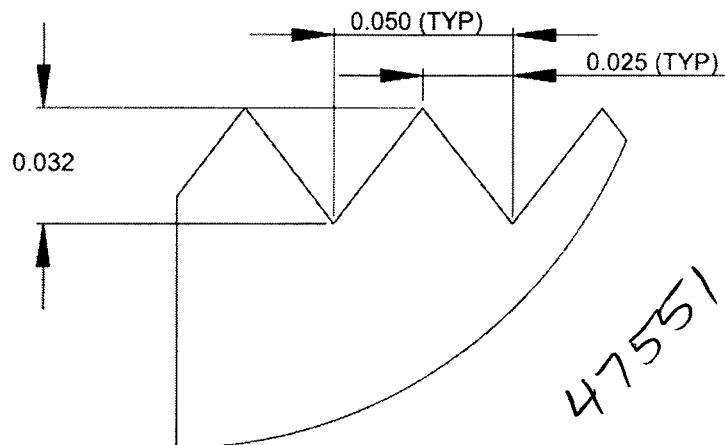
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) ENGRAVE DART P/N & LOGO AS SHOWN
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

RELEASED
04 23 01DETAIL B (20 : 1)**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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